

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025739**Date Inspected:** 17-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** OBG 13BE, 13AW**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

This Quality Assurance (QA) Inspector has performed documentation review of the Green Tag system utilized by American Bridge/Flour (ABF) and Caltrans METS. This QA Inspector has Identified Complete Joint penetration (CJP), Partial Joint Penetration (PJP), and Fillet Welds in Lift 13BE. He has also verified the Non-Destructive Testing requirements for each weldment that includes the NDT process (UT, MT, and RT) and the percentage required by the contractor to perform. These items are within the Contract special provision, CCO 22 and within compliant of CCO 77. This information has been documented and compiled in a Green Tagging spread sheet that is located on the Caltrans Team China Z; drive.

**TRIAL ASSEMBLY YARD**

This QA inspector monitored testing of magnetic particle yokes used by ZPMC, and AB/F for testing of OBG welds with Interzink 22 primer located in contact area. Yokes were tested using a 10lb.+ steel plate with Interzink 22 primer with a DFT of 2 to 4 mils.

This Caltrans QA inspector received AB/F non-destructive test (NDT) notification number 09752 for ZPMC Trial Assembly Yard. This QA inspector performed Ultrasonic Testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG 13AW. The weld designations reviewed are as follows.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

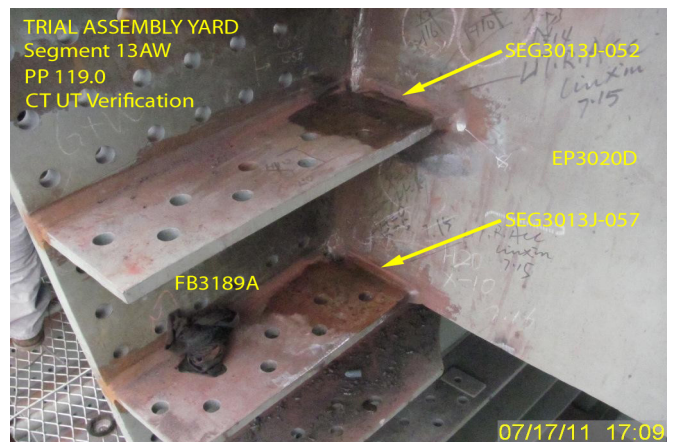
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SEG3013C-158  
FB3178-001-169  
FB3186-001-120  
SEG3013C-204, 209, 214, 219, 224, 229  
SEG3013J-049, 052, 057  
SEG3013G-049, 054, 059, 064, 044  
SEG3013J-043, 046

This Caltrans QA inspector received AB/F non-destructive test (NDT) notification number 09756 for ZPMC Trial Assembly Yard. This QA inspector performed Ultrasonic Testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG 13AW. The weld designations reviewed are as follows.

SEG3013AH-172, 175  
SEG3013B-047  
SEG3013N-210  
SEG3015B-239  
SEG3014X-091

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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## WELDING INSPECTION REPORT

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**Inspected By:** Combs,Dennis

Quality Assurance Inspector

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**Reviewed By:** Riley,Ken

QA Reviewer